



Koolkut® Spectrum

Phillips 66® Koolkut® Spectrum is a general-purpose, active cutting oil developed for medium- to heavy-duty machining of cast iron, stainless steel, high-speed steel, and other alloys. It is specially formulated with high-quality base oils and fortified with sulfur-containing extreme-pressure additives that provide good anti-weld properties and reduced friction at the chip-tool interface, resulting in extended tool life and good surface finishes on the machined parts.

Koolkut Spectrum can cause staining of non-ferrous metals such as copper and copper alloys, and is not recommended for machining non-ferrous metals if staining is objectionable.

Applications

- Boring
- Broaching
- Drilling
- Milling
- Tapping
- Threading

Features/Benefits

- Excellent performance in most difficult machining operations
- Good anti-weld properties
- Helps extend cutting tool life
- Good surface finish
- Transparent for good visibility of the machining operation

General-Purpose Cutting Oil





Koolkut® Spectrum

Typical Properties	
ISO Grade	32
Specific Gravity @ 60°F	0.885
Density, lbs/gal @ 60°F	7.37
Color, ASTM D1500	1.5
Flash Point (COC), °C (°F)	216 (421)
Pour Point, °C (°F)	-20 (-4)
Viscosity	
cSt @ 40°C	32.0
cSt @ 100°C	5.4
SUS @ 100°F	165
SUS @ 210°F	44.4
Viscosity Index	102
Copper Corrosion, ASTM D130	1b
Chlorine, wt %	1.18
Fatty Oil, wt %	Nil
Sulfur, Total, wt %	1.08
Sulfur, Active, wt %	0.7

Health & Safety Information

For recommendations on safe handling and use of this product, please refer to the Safety Data Sheet via <http://www.phillips66.com/EN/products/Pages/MSDS.aspx>.

07-12-16

Typical properties are average values only and do not constitute a specification. Minor variations that do not affect product performance are to be expected during normal manufacture, and at different blending locations. Product formulations are subject to change without notification.

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